



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3121-141
Job Sheet 169666



Part No: D3121-141

Job Qty: 6 ea

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 12/18/17

Job Tracking No:

Due Date: 12/22/17

Created By: Jason Leroux

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		12/21/17	0.00	0.00	Start Up Machining-1		<i>[Signature]</i>
100	Bandsaw	6 pcs		12/21/17	0.00	0.68	Bandsaw1		<i>[Signature]</i>
110	CNC Vertical Machining	6 pcs		12/21/17	0.47	11.76	HAAS1-3		<i>[Signature]</i>
120	QC	6 pcs		12/21/17	0.00	0.00	QC2 Machining-1		<i>[Signature]</i>
130	QC	6 pcs		12/21/17	0.00	0.00	QC8 Machining-1		<i>[Signature]</i>
140	Small Fab	6 pcs		12/22/17	0.00	0.17	Small Fab-2		<i>[Signature]</i> DAS
150	QC	6 pcs		12/22/17	0.00	0.00	QC5		<i>[Signature]</i> 38
160	Packaging	6 pcs		12/22/17	0.00	0.00	Packaging3-1	57.018	<i>[Signature]</i> 50 38
170	QC21-SA	6 Ea		12/22/17	0.00	0.00	QC21		<i>[Signature]</i>

Part Op 100 - Cut blanks: (1.250" x 2.000") 6.600" long

Descriptions: 110 - 1-Machine D3121-111 as per Folio FA361 and Dwg D3121 Identify as D3121-111 3-Scribe batch number

140 - Assemble D3121-141 as per Dwg D3121.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M17-4-B1.250X02.000	3	3	0	0
140-Small Fab	D3121-21 5000786 5x	6	50	0	0
	D3121-241 5024941	6	23	0	0

Part Specifications

Specifications could not be found.

M17-4 1.00x2.00 5021298 → 5021298

Plex 12/18/17 2:06 PM dart.leroux.jason

DART
AEROSPACE
S024381



Bracket Assembly

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PART NO:
Revision:
Operation:
Change No:

D3121-141

Start up Operation

Mfg Date: 12/18/17
Job No: 169666

DART AEROSPACE LTD		Work Order: 169023
Description: Bracket		Part Number: D3121-111
Inspection Dwg: D3121	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	.393	✓		micrometer	
0.75	+/-0.030	.750	✓		vernier	
0.375	+/-0.010	.375	✓		vernier	
2.14	+/-0.030	2.141	✓		Vernier	
1.96	+/-0.030	1.968	✓		Vernier	
0.280	+/-0.010	.281	✓		Vernier	
3.330	+/-0.010	3.320	✓		Vernier	
3.630	+/-0.010	3.629	✓		Vernier	
R0.25	+/-0.030	R.250	✓		Gaborit	
R0.375	+/-0.010	R.375	✓		Gaborit	
Ø0.201	+/-0.010	.200	✓		vernier	
0.100	+/-0.010	0.098	✓		vern.	
4.580	+/-0.010	4.575	✓		high gage	
6.18	+/-0.030	6.181	✓		vernier	
5.89	+/-0.030	5.886	✓		high gage	
0.080	+/-0.010	.081	✓		vernier	
0.300	+/-0.010	.301	✓		vernier	
30°	+/-0.1°	30°	✓		Gaborit	
R0.25	+/-0.030	R.250	✓		Gaborit	
0.130	+/-0.010	.127	✓		vernier	
0.664	+/-0.010	.665	✓		high gage	
0.381	+/-0.010	.378	✓		Vernier	
0.201	+/-0.010	.199	✓		Vernier	
0.400	+/-0.010	.396	✓		Vernier	
0.580	+/-0.010	.575	✓		Vernier	
100°	+/-0.1°	-100°	✓		Gaborit	
0.032	+0.000/-0.010	0.029	✓		K.T.-04.	

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: 2017/12/14	Date: 17-12-19	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue P/O D3121-141	KJ/RF	
B	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	
D	08.01.16	Dimensions updated per Dwg Rev. E	KJ/EC/DD	
E	08.05.28	Tolerance revised for Ø0.201 dimension	KJ/DD	
F	13.10.22	Tolerance revised for Ø0.201 dimension	KJ	<i>[Signature]</i>